

Date: Friday, 20/02/2009 9:11:36 AM  
 User: Jean-Luc Menard

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
<b>Job Number</b>	: 45921					
<b>Estimate Number</b>	: 10530					
<b>P.O. Number</b>	:			<b>Part Number</b>	: D2571	
<b>This Issue</b>	: 20/02/2009		<b>S.O. No.</b>	: D2571 REV E		
<b>Prsht Rev.</b>	: NC			<b>Project Number</b>	: N/A	
<b>First Issue</b>	: / /		<b>Type</b>	: MACHINED PARTS		
<b>Previous Run</b>	: 43564			<b>Drawing Revision</b>	: E	
<b>Written By</b>	<u>JL 09.02.20</u>			<b>Material</b>	:	
<b>Checked &amp; Approved By</b>	:			<b>Due Date</b>	: 27/02/2009	
<b>Comment</b>	: Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ					

## Additional Product

Job Number:	
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Seq. #:	Machine Or Operation:	Description :	
1.0	D6101007	Saddle Billet	

Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571

Ensure that grain is along 7.75" length

Batch No: B42991

MJ 09/02/09

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
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Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No: 09/02/09 Double check by: DJP

B45921

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets

4-Deburr and remove all machining marks

5-Tumble to remove sharp edges.

MJ 09/02/09 SP 09/02/09

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
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Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

MJ 09/02/09 SP 09/02/09

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MJ 09/02/09 SP 09/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: DZ571 PAR #: N/A Fault Category: Prod/Machined Parts NCR: Yes No DQA: ID Date: 09/03/03  
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: ID Date: 09/03/03

NCR: 45921		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.02.25	2	Thickness under tolerance on one side, over tol on other (0.110/0.145)	JP 09.02.25 pr QSI 042	SCRAP PART. Misalignment between holes and bore likely to cause fit problem.	SV 09/02/03	S 09/02/03	JP 09.02.25 pr QSI 042	S 09/02/03

NOTE: Date & initial all entries

Date: Friday, 20/02/2009 9:11:37 AM

User: Jean-Luc Menard

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 45921

Part Number: D2571

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

J.L 09/02/26

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

B12 09-02-26

(10)

7.0 POWDER COATING POWDER COATING



m/09996

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

(11)

START TIME: 7:45

OVEN TEMPERATURE: 320°

FINISH TIME: 8:15

Fx 09/03/02

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



MS

09-03-02

X 11

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



1X

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 733

9/3/h

S/

10.0 QC21 FINAL INSPECTION/W/O RELEASE



09/03/02 (12)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-03-02

DART AEROSPACE LTD	Work Order:	45921
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		.500	.500	.500	.500		
G	0.257	0.262		.259	.259	.259	.259		
H	0.375	0.380		.375	.376	.376	.376		
I	0.490	0.510		.495	.503	.500	.503		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.562	.570	.563	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.496	1.495	1.495	1.495		
N	2.495	2.505		2.499	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.873	3.873	3.873		
P	0.115	0.135		.130	.129	.130	.130		
Q	0.115	0.135		.135	.136	.135	.135		
R	0.240	0.260		.256	.253	.250	.248		
S	0.115	0.135		.135	.126	.128	.120		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.961	2.961	2.961		
V	0.230	0.250		.245	.243	.242	.240		
W	0.115	0.135		.135	.128	.130	.127		
X	0.308	0.313		.313	.313	.313	.313		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.369	.369	.369	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.388	1.388		
AF	0.115	0.135		.124	.124	.124	.124		
AG	0.240	0.280		.250	.250	.250	.250		
AH	0.240	0.260		.250	.250	.250	.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	88	Audited by:	J.L
Date:	09/02/21	Date:	09/02/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	20 JLM

DART AEROSPACE LTD	Work Order:	45921
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge		
A	0.438	0.443	.438	.438	.438
B	1.745	1.755	1.750	1.746	1.746
C	3.495	3.505	3.500	3.496	3.497
D	1.745	1.755	1.750	1.745	1.746
E	7.990	8.010	8.000	8.000	8.000
F	0.490	0.510	.500	.504	.493
G	0.257	0.262	.259	.259	.259
H	0.375	0.380	.376	.376	.376
I	0.490	0.510	.502	.500	.503
J	1.174	1.184	1.179	1.179	1.179
K	0.558	0.578	.571	.570	.570
L	1.174	1.184	1.179	1.179	1.179
M	1.490	1.500	1.500	1.500	1.500
N	2.495	2.505	2.500	2.500	2.500
O	3.869	3.879	3.874	3.873	3.873
P	0.115	0.135	.131	.126	.128
Q	0.115	0.135	.130	.130	.130
R	0.240	0.260	.254	.253	.254
S	0.115	0.135	.123	.123	.119
T	0.178	0.198	.188	.188	.188
U	2.940	2.980	2.960	2.963	2.963
V	0.230	0.250	.246	.240	.245
W	0.115	0.135	.127	.127	.129
X	0.308	0.313	.312	.312	.313
Y	0.760	0.765	.760	.760	.761
Z	0.352	0.372	.363	.362	.363
AA	0.470	0.530	.500	.500	.500
AB	0.615	0.635	.630	.629	.629
AC	0.053	0.073	.063	.060	.063
AD	0.240	0.260	.250	.250	.250
AE	1.375	1.395	1.388	1.380	1.380
AF	0.115	0.135	.125	.125	.125
AG	0.240	0.280	.260	.260	.260
AH	0.240	0.260	.257	.257	.257
AI	2.000	2.020	2.000	2.000	2.000
AJ	0.023	0.043	.033	.033	.033

Accept/Reject

Measured by:	SP / mm	Audited by:	J.L.
Date:	09/02/23 / 09/02/24	Date:	09/02/26

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	JLM SP

DART AEROSPACE LTD

Work Order:

45921

Description: Saddle, Fwd Outboard

Part Number:

D2571

Inspection Dwg: D2571 Rev. E

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9	10	11	12	By	Date
A	0.438	0.443		.440	.440	.439	.439		
B	1.745	1.755		1.747	1.747	1.747	1.746		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.747	1.747	1.747	1.747		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.509	.490	.491	.491		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.375	.376	.376	.375		
I	0.490	0.510		.504	.502	.502	.503		
J	1.174	1.184		1.180	1.178	1.177	1.178		
K	0.558	0.578		.575	.573	.573	.573		
L	1.174	1.184		1.177	1.178	1.179	1.178		
M	1.490	1.500		1.494	1.495	1.494	1.495		
N	2.495	2.505		2.499	2.504	2.504	2.505		
O	3.869	3.879		3.871	3.872	3.872	3.872		
P	0.115	0.135		.131	.130	.131	.130		
Q	0.115	0.135		.130	.130	.130	.130		
R	0.240	0.260		.254	.254	.253	.253		
S	0.115	0.135		.126	.125	.124	.125		
T	0.178	0.198		Q.188	Q.187	Q.187	Q.187		
U	2.940	2.980		2.959	2.960	2.958	2.959		
V	0.230	0.250		.249	.243	.243	.241		
W	0.115	0.135		.122	.116	.116	.115		
X	0.308	0.313		.312	.313	.312	.312		
Y	0.760	0.765		.761	.760	.760	.760		
Z	0.352	0.372		.362	.362	.362	.362		
AA	0.470	0.530		.502	.502	.502	.502		
AB	0.615	0.635		.634	.635	.634	.634		
AC	0.053	0.073		.062	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.133	.130	.130	.131		
AG	0.240	0.280		.251	.262	.263	.252		
AH	0.240	0.260		.258	.254	.249	.253		
AI	2.000	2.020		2.000	2.000	1.998	1.999		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: *mmf*Audited by: *JL*Date: *09/02/25*Date: *09/02/26*

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	<i>JL</i> <i>JLM</i>

